



Dart Aerospace Ltd.
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Tel (613) 632-5200

D3913-041
Job Sheet 175092



Part No: D3913-041

Job Qty: 1 ea

Part Name: Long Basket Base Assembly, 350



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/27/18

Job Tracking No:

Due Date: 5/4/18

Created By: Michelle Gagnon-Donovan

Type: Stock

Description:

Note: DWG D4020 REV A SHEET 4, D3913 REV D SHEETS 1,2,3,4,5 IPP Rev:A new issue DD 10.03.19 verified by:EC IPP Rev:B chg qty's DD 10.04.12 verified by:EC IPP REV:C 12.07.24 AS PER DWG REV.B DD VERF:EC IPP REV:D 13.08.21 DWG REV.C / ECN 13-624 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		5/3/18	0.00	0.00	Start Up Large Fab-5		DC 2018-05-01
100	Large Fab	1 pcs		5/3/18	0.00	10.00	Large Fab 1		2018-05-06
110	QC	1 pcs		5/3/18	0.00	0.00	QC9		CP
120	QC	1 pcs		5/3/18	0.00	0.00	QC5		CP
125	HandFinish	1 pcs		5/3/18	0.00	0.29	HandFinish2		2018-05-08
130	Powdercoat	1 pcs		5/3/18	0.00	0.93	Powdercoat2		2018-05-08
135	Packaging	1 pcs		5/3/18	0.00	0.00	Packaging1		2018-05-09
140	QC	1 pcs		5/3/18	0.00	0.00	QC3		2018-05-08
150	HandFinish	1 pcs		5/4/18	0.00	0.50	HandFinish4		2018-05-08
160	QC	1 pcs		5/4/18	0.00	0.00	QC5		2018-05-09
170	Packaging	1 pcs		5/4/18	0.00	0.00	Packaging3-2		2018-05-09
180	QC21-SA	1 Ea		5/4/18	0.00	0.00	QC21		2018-05-09

Part Op 100 - 1- assemble ribs , weld as per dwg D3913 using DT9610A ***inspect before welding mesh*** 2-Cut D4020-1 base
Descriptions: mesh and tack weld all mesh on basket as per dwg D3913 and trim mesh to fit if necessary and trim to clear fasteners
holes on the ends 3- weld hinge (3) and Mounting brackets as per dwg D3913 ***take lid to locate hinge and bracket*** 4-
Weld D4672-1 blanking plates as per dwg
130 - 1- Plug holes and mask only interior of hinge (3) prior to powder coat
150 - Pick Kit

M/18760 START: 2:15 O.V.T. 3:50 FINISH 2:30

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
D2581	Mounting Bracket	2 Ea (2 ea)	90-Start up Operation	5054665
D3913-1	Rib	1 Ea (1 ea)	90-Start up Operation	5049419
D3913-15	Wide Handle Plate	1 Ea (1 ea)	90-Start up Operation	5043834
D3913-3	Rib	1 Ea (1 ea)	90-Start up Operation	5054823
D3913-7	Rib	2 Ea (2 ea)	90-Start up Operation	5054996
D3913-9	Hinge Rib	1 Ea (1 ea)	90-Start up Operation	5054004
D3916-041	Rib Assembly	2 Ea (2 ea)	90-Start up Operation	5060590
D3916-5	Light Rib	3 Ea (3 ea)	90-Start up Operation	5065866
D4016-1	Hinge Half, Base	3 Ea (3 ea)	90-Start up Operation	5062521
D4017-7	Rib	3 Ea (3 ea)	90-Start up Operation	5045854
D4017-9	Rib	2 Ea (2 ea)	90-Start up Operation	5060229
D4020-11	End Mesh, Basket	2 Ea (2 ea)	90-Start up Operation	5057517
D4021-1	Handle Plate	3 Ea (3 ea)	90-Start up Operation	5057128
D4034-041	Aft Upper Rib Assembly	1 Ea (1 ea)	90-Start up Operation	5059794
D4034-043	Fwd Upper Rib Assembly	1 Ea (1 ea)	90-Start up Operation	5062265
D4672-1	Blanking Plate	2 Ea (2 ea)	90-Start up Operation	5054936
M304EX0.75-16F	Expanded Metal Flat SS	33 sf (33 ea)	90-Start up Operation	5049718
AN3-10A	Bolt	6 Ea (6 ea)	150-HandFinish	5041477
D2931	Bumper	2 Ea (2 ea)	150-HandFinish	F86435
MS20600-AD4W3	Cherry Rivet	2 Ea (2 ea)	150-HandFinish	5042091
MS21042L3	Nut	6 Ea (6 ea)	150-HandFinish	5054102
NAS1149F0332P	Washer	12 Ea (12 ea)	150-HandFinish	5057523
D4021-5	Blanking Plate	2 Ea (2 ea)	150-HandFinish	5059022

Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
90-Start up Operation	D2581	2	84	0	
	D3913-1	1	12	0	
	D3913-15	1	13	0	
	D3913-3	1	14	0	
	D3913-7	2	29	0	
	D3913-9	1	8	0	
	D3916-041	2	10	0	
	D3916-5	3	18	0	
	D4016-1	3	13	0	
	D4017-7	3	42	0	
	D4017-9	2	10	0	
	D4020-11	2	20	0	
	D4021-1	3	13	0	
	D4034-041	1	8	0	
	D4034-043	1	8	0	
	D4672-1	2	64	0	
	M304EX0.75-16F	33	788	0	
150-HandFinish	AN3-10A	6	252	0	
	D2931	2	1,102	0	
	D4021-5	2	19	0	
	MS20600-AD4W3	2	207	0	
	MS21042L3	6	3,099	0	
	NAS1149F0332P	12	1,987	0	

Part Specifications

Specifications could not be found.

M.U.002859

Plex 3/27/18 11:29 AM Dart.Gagnon.Michelle

Master Unit 002859



Job No 175092



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Container No: S067248



Part: D3913-041

Job No: 175092

Serial No/Batch: S067248

Revision:

Inspector:

Date: 05/01/18